

Work Order ID 144419

Monday, April 18, 2016 8:14:42 AM

144419

Page 1

Item ID: D5227-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Seat Track

Start Date: 4/18/2016 Start Qty: 6.00

6

Cust Item ID:

Required Date: 4/29/2016 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: DAS 21 Date: 1509-19 Tooling: _____ Date: _____
QC: 9-89 Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D5227

A

100

0.00

100

BAND SAW

Bandsaw

Memo

0.50

Jeaspa Bandsaw

Cut Blank at 29.375"

6

1

P16-08-17

110

0.13

110

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

9.90

HAAS CNC vertical machine #1

1-Machine per folio FB379

DWG REV: AFOLIO REV: AA

2- deburr and break all sharp edges

6

1

P16-08-17
DAS 44 16-08-18
9-89PTO
→

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coor. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval 	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐ _____					

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Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
120									
QC	Memo	0.06				6	1		
Quality Control									DAS 44 16-08-17 9-89
130	QC8- Inspect parts - second check	0.00							
130									
QC	Memo	0.12				6	0		
Quality Control									DAS 08 9-89
140	Outsource process-Anodize per QSI017 4.1.10.1	0.00							
140									
Outsource4	Memo	432.00				6			
Outsource process - Anodize	Issue P/O: 33389 Black Anodize as per Dwg D5227								AUG 23 2016 DAS 13 9-89

DQA: dw Date: 2016-10-7



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: REAN Date: OCT 03 2016

Work Order update only ☐

Work Order: <u>144419</u>	DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS					
Part No. <u>D5227-1</u>		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐		
NCR No. <u>16-6067</u>		Machining ☒	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐		
		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐		
		Large Fab ☐	Composite ☐	Supplier ☐			

Date : 16-08-18 Step #: 110 QTY Effective : ① MRB (QSI042) Approval

Description Work Order Deviation dimension .120 ^{+0.005} / _{-.000} (1.c-8) is .117" R.C. operator	Disposition scrap destroy Replace. <u>B 133981</u>	DAS 9 16-08-18 Completed By DAS 44 16-08-19 Lead hand / Supervisor Approval Verification B. 16/08/18 QC / QA Coordinator Approval 16-08-19
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Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☒	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☒
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐				
Misidentified ☐	Past Due ☐	OTHER :			

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Receive & Inspect for Damage & Mat'l Certs	0.00							
150									
Packaging	Memo	0.12							
Packaging									Pb →
155	QC5- Inspect part completeness to step on W/O	0.00							
155									
QC	Memo	0.12							
Quality Control									DAS 6 9-89
180	Identify as per dwg & Stock Location: <u>57369</u>	0.00							
180									
Packaging	Memo	0.06							
Packaging									SEP 19 2016 DAS 6 9-89

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☒

Work Order: <u>1444B</u> Part No. <u>05227-1</u> NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coor. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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Date : <u>2006/09/12</u>		Step #: <u>155</u>		QTY Effective : _____			MRB (QSI042) Approval <u>DAS</u> <u>16</u> <u>9-89</u> <u>16/09/12</u>																																																																
Description Work Order Deviation change step #155 to QC 6 inspection level				Disposition 				Completed By <u>DAS</u> <u>10</u> <u>9-89</u>																																																															
				Lead hand / Supervisor Approval Verification																																																																			
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Work Order ID 144419

Monday, April 18, 2016 8:14:42 AM

144419

Page 4

Item ID: D5227-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Seat Track

Start Date: 4/18/2016 Start Qty: 6.00

6

Cust Item ID:

Required Date: 4/29/2016 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00

SEP 19 2016

190

QC

Memo

0.60

DAS
21
9-89

Quality Control

DAS
21
9-89

SEP 19 2016

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation		Disposition			

Root Cause			FAULT CATEGORY			
Environment ☐	☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
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Past Expiry Date ☐	☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	☐	Past Due ☐				

Picklist Print

Monday, April 18, 2016 8:14:48 AM

Page 1

Work Order ID: 144419

144419

Parent Item: D5227-1

D5227-1

Parent Item Name: Seat Track

Start Date: 4/18/2016

Required Date: 4/29/2016

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev: A RQ verified by: DD 15.04.09

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M7075T73B1.250X02.0 00		Purchased	No				f	24.0000		15.78947			

M7075T73B1 250X02 000

7075-T73 BAR 1.250" X 2.000"

Location

Loc Qty

Loc Code

MAT

24

m133981

24

17.2

16-08-17

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Past Expiry Date ☐	☐	Manufacturing Process ☐	OTHER : _____						
Misidentified ☐	☐	Past Due ☐							

DART AEROSPACE LTD		Work Order: 144 419
Description: Seat Track		Part Number: D5227-1
Inspection Dwg: D5227	Rev: A	Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.120	+0.005/-0.000					
Ø0.250	+0.005/-0.001	.250				
0.45 Deep	+/-0.030	.450				
Ø0.209	+0.005/-0.001	.209				
8.910	+/-0.010	8.910				
7.660	+/-0.010	7.660				
6.450	+/-0.010	6.450				
5.240	+/-0.010	5.240				
4.030	+/-0.010	4.030				
2.820	+/-0.010	2.820				
1.610	+/-0.010	1.610				
0.400	+/-0.010	.400				
0.550	+/-0.010	.557				
0.938	+/-0.010	.938				
4.38	+/-0.030	4.375				
0.750	+/-0.010	.750				
0.293	+/-0.010	.288				
28.83	+/-0.030	28.830				
21.59	+/-0.030	21.590				
4.80	+/-0.030	4.797				
10.00	+/-0.030	10.00				
0.75	+/-0.030	.748				
0.35	+/-0.030	.350				
0.50	+/-0.030	.500				
Ø0.209	+0.005/-0.001	.209				
0.205	+/-0.010	.205				
R0.125	+/-0.010	.125				
0.790	+/-0.010	.790				
0.585	+/-0.010	.576				
1.500	+/-0.010	1.497				
0.032 x 45°	+/-0.010 x +/-0.5°	.032 x 45°				
0.30	+/-0.030	.301				
R0.032	+/-0.010	.032				
0.53	+/-0.030	.525				
R0.063	+/-0.010	.063				

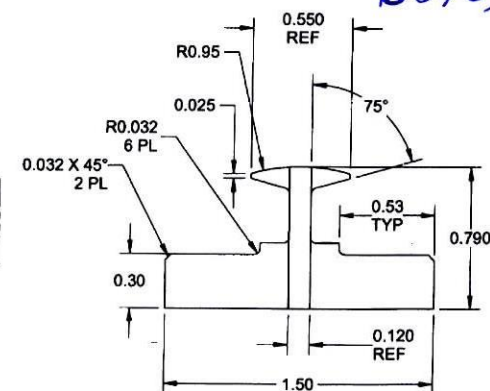
Measured by: J160817/FR	Checked by: DAS	QC Inspector:
Date: 16-08-18	Date: 16/08/23	Date:

Engineering Approval: (If necessary)	Date:
--	--------------

Rev	Date	Change	Revised by	Approved
A	15.07.23	New Issue	KJ	



NO. 136421 MJS
1509-03



VIEW A-A
RELEASE
2015-06-16
EWN 15-578 @

NOTES:

- 1) MATERIAL: 7075-T73 (OR 7075-T7351/T73510/T73511) BAR
PER AMS-QQ-A-200/11 (OR AMS-QQ-A-225/9 (AMS 4124)
OR AMS-QQ-A-250/12 (AMS 4078)
REF DART SPEC M7075T73B
- 2) FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044.6.1
- 7) WEIGHT: 0.42 lbs
- 8) REFERENCE TO CAD FILE D5227-1.SLDPRT REV. A FOR NON-DIMENSIONED DETAILS

A	NEW ISSUE	AK	15.03.20
REV.	DESCRIPTION		BY DATE
DESIGN	AK	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AK		
CHECKED	VS	DRAWING NO.	REV. A
MFG. APPR.	JLM	D5227	SHEET 1 OF
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	SEAT RAIL	NTS
DATE	15.03.20	COPYRIGHT © 2015 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT	

APPROVED



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO33389

Purchase Order Date 8/23/2016
PO Print Date 8/30/2016

Page Number 3 of 3

Order From :

A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE ROAD
ROCKLAND, ON K4K 1T2
CANADA

VC-ATG001

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone

613-446-4544

Ship To Contact

Ship To Phone

Ship Via:

Ship Acct:

VENDOR'S TRUCK

Buyer

Customer POID

Customer Tax #

Terms

Currency

FOB

Chantal Lavoie

10127-2607

Net 30

CAD

FCA - (Free Carrier)

6	71401-45	ADMIN FEE	8/30/2016	1.00	\$150.00	\$150.00
			No	Each		
			8/30/2016			

Line Total: \$150.00

7	144419	D5227-1 SEAT TRACK REV. A	9/7/2016	6.00	\$21.00	\$126.00
			Yes			
			9/7/2016			

HARD BLACK ANODIZE AS PER IWA MIL-A-8625 TYPE III, CLASS 2

Line Total: \$126.00

8	146598	646.9810 DEFLECTOR REV. A	9/7/2016	6.00	\$47.25	\$283.50
			Yes			
			9/7/2016			

FINISH: HARD BLACK ANODIZE AS PER IAW MIL-A-8625 TYPE III, CLASS 2 / PRIME AS PER IAW MIL-P-23377J TYPE I CLASS N

Line Total: \$283.50

PO Total: \$927.90

Note: Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Change Nbr: 4

Change Date: 8/30/2016



A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE STREET
ROCKLAND, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 912211

Date: 07-Sep-16

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

CHANTAL LAVOIE
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
Quantity	Description		
	PLEASE REFERENCE THE PACK LIST NUMBER ON ALL CORRESPONDENCE TO THIS SHIPMENT. IF YOU HAVE ANY QUESTIONS, PLEASE CALL AT (613) 446-4544.		
12 ea	Part: 646.3812 GUSSET BRACKET Job: 20010	PO: 33389	Rev: N/C Line: 3
7 ea	Part: 646.3714 Gusset Job: 20011	PO: 33389	Rev: A Line: 4
1 ea	Part: ADMINISTRATION FEE ADMINISTRATION FEE Job: 20012	PO: 33389	Rev: N/A Line: 6
6 ea	Part: D5227-1 Seat track Job: 20013	PO: 33389	Rev: A Line: 7
6 ea	Part: 646.9810 Deflector Job: 20014	PO: 33389	Rev: A Line: 8
DATE: <u>7/9/16</u> CERTIFIED SIGNATURE: <u>[Signature]</u> RECEIVER SIGNATURE: _____			
Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.			
CERTIFICATE OF CONFORMANCE			
A.T.G. INDUSTRIES INC. CERTIFIES THAT ALL ITEMS IN THIS SHIPMENT CONFORM TO			



A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE STREET
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Fax: 613 632-1053

Terms		Ship Via	
Quantity	Description		
	REQUIREMENTS.		
	MADE IN CANADA.		
	Sp/6-9-7		